

Date: Monday, 07/04/2008 11:46:58 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FWD X-TUBE
Job Number :	38422		
Estimate Number :	10006		
P.O. Number :		Part Number :	D2889
This Issue :	07/04/2008	Drawing Number :	D2889 REV B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	B
Previous Run :	38399	Material :	
Written By :		Due Date :	10/05/2008
Checked & Approved By :	<i>JD 08.4.06</i>	Qty:	1 Um: Each
Comment :	Est Rev:A New Issue 05-10-25 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6005180	Crosstube material
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Crosstube material

Pick:

Qty Part number Description Batch

1 D2889 Fwd Crosstube

B34687

EL 8-4-23

2.0	BENDING	BENDING MACHINE - SKIDTUBES
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**Comment:** LANDING GEAR RESOURCE 1

1-Bend D2889 as per Dwg D2889 and Folio FT001

EL 8-4-23

3.0	SKIDTUBES 1	SKIDTUBES RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Deburr and Polish

*used on w/o # 38711**used on w/o # 38711*

4.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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**Comment:** DIMENSIONAL CHECK OF X-TUBES*used on w/o # 38711*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Acid etch and alodine as per QSI 005 4.1
 Inside and outside of tube

used on w/o # 38711

Date: Monday, 07/04/2008 11:46:59 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE

Job Number: 38422

Part Number: D2889

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

NA

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

NA
used on w/o # 38711
08/04/03

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/24 JA

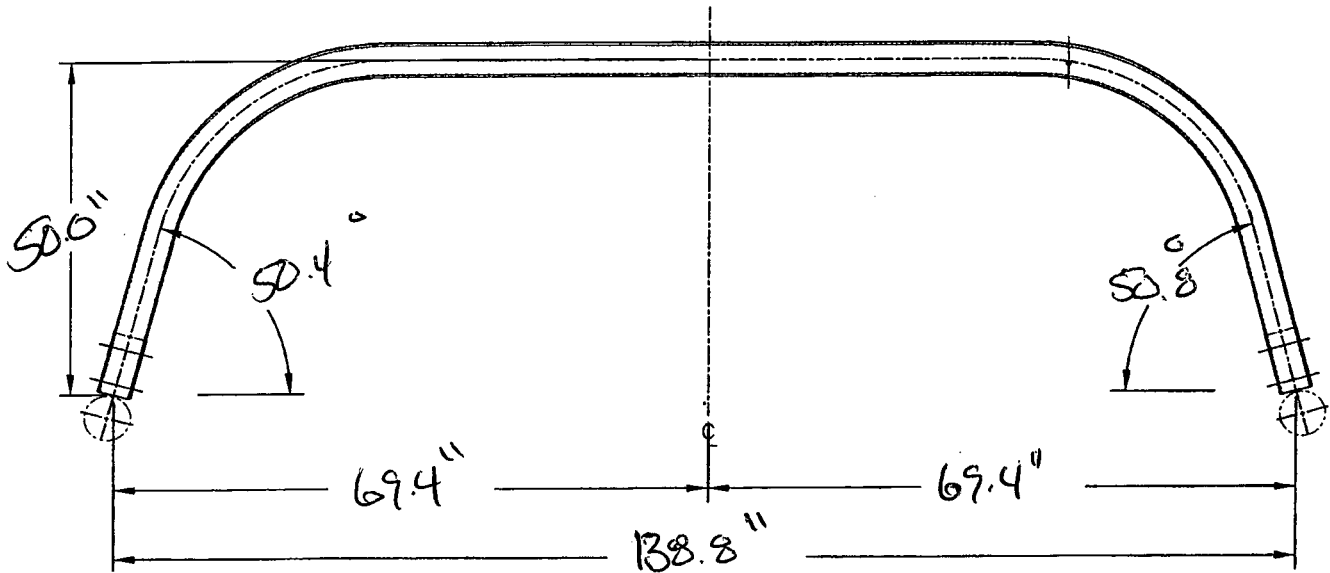
Job Completion



MF 08-04-24

DART AEROSPACE LTD		Work Order: 38422
Description: Crosstube Fwd		Part Number: D2889
Inspection Dwg: D2889	Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments
* used used on w/o# 38711

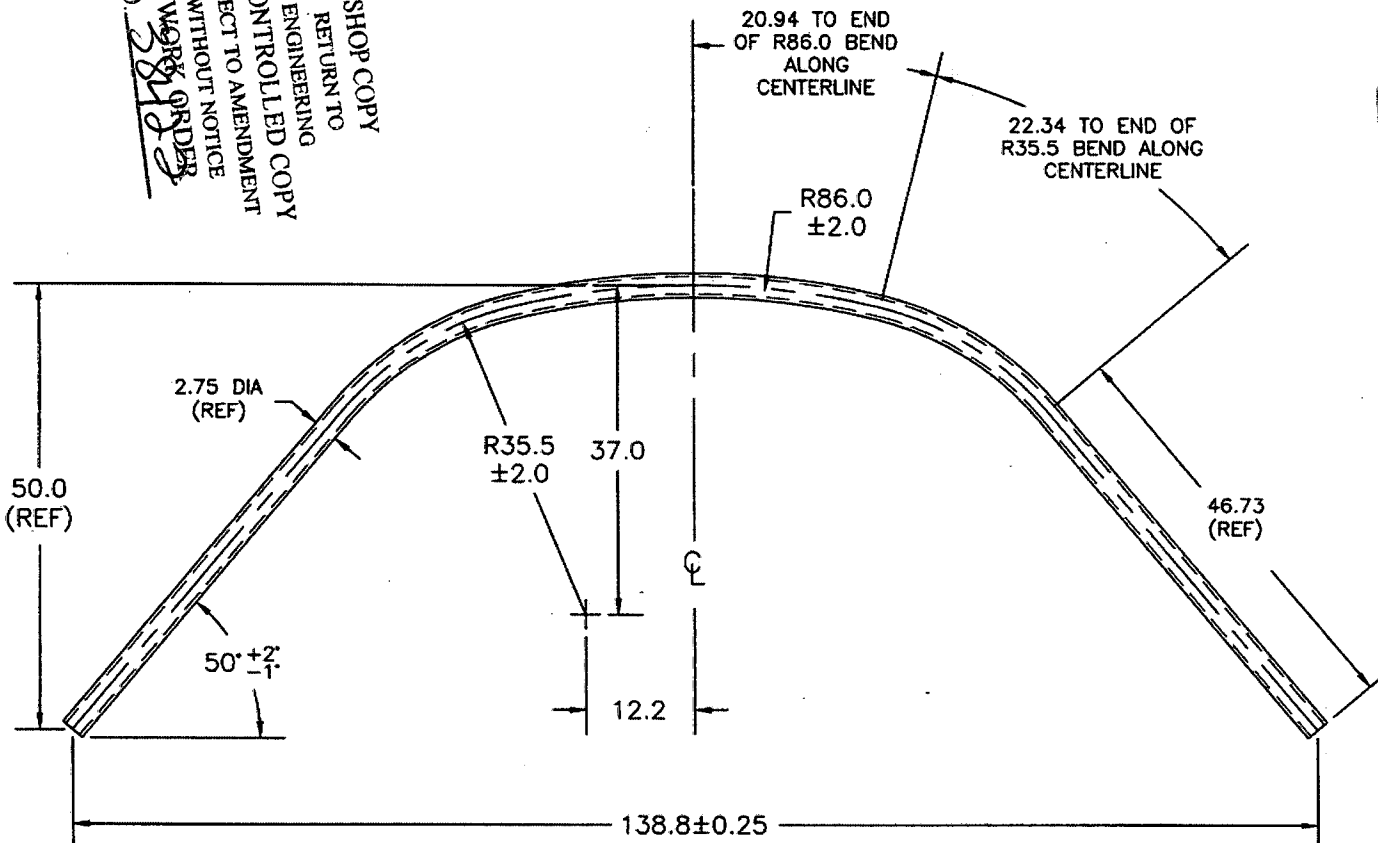
QC15 Inspection	08/04/23
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>[Signature]</i>



RELEASED
02.10.28

DESIGN	DRAWN BY	DART AEROSPACE LTD
#	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
#	#	D2889
DATE	TITLE	REV. B
02.10.18	FWD CROSSTUBE	SHEET 1 OF 1
A	99.05.21	SCALE
B	02.10.18	1:20
ADD TANGENT LENGTHS; CHANGE NOTES		



SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28423

NOTES

- 1) MATERIAL: MANUFACTURE FROM D6005-180 ($\phi 2.75$ OD x 0.375 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

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